



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3294-1
Job Sheet 208149



Part No: D3294-1

Job Qty: 40 pcs

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/12/20

Job Tracking No:

Due Date: 3/27/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs			0.17	3.21	Waterjet - Flow		TF March, 20, 2020
110	QC 2	10 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		TF March, 20, 2020
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	10 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
130 Small Fab - Brake NC - B4B	10 pcs	0.25 1.38	QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	DAS APR 23 2020 40 9-89
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
140 QC 5	10 pcs	0.00 0.00	Small Fab - Brake - 1 - B4B	
			Small Fab - Brake - 2 - B4B	
			Small Fab - Brake - 3 - B4B	APR 16 2020
150 Handfinish - 1-1 Chemical-	10	0.00 0.76	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	DAS 40
			QC 5 - 30	
			QC 5 - 40	APR 16 2020 9-89
			QC 5 - 61	
			QC 5 - 81	
150 Handfinish - 1-1 Chemical-	10	0.00 0.76	Handfinish - 1 - 1 - B4B	2 FEB 24 2020 12

B4B	pcs		Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
160 QC 7	10 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
170 Small Fab - 2 - B4B	10 pcs	0.00 1.57	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	

20-04-17

20-04-17

DAS
58
9-89

APR 21 2020

			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
180 QC 5	10 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	DAS
			QC 5 - 30	82
			QC 5 - 40	9-89
			QC 5 - 61	
			QC 5 - 81 QC 5 - 82	APR 22 2020
190 Powdercoat - 4 Black Sand - B4B	10 pcs	0.00 0.44	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20.04.23
			Powdercoat - 4 - B4B	
200 QC 3	10 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	BE 820-04-23
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
210 Packaging 3-1 - Stock - B4B	10 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	

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			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	DAS
			Packaging 3 - 10 - B4B	28
			Packaging 3 - 11 - B4B	9-89
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
220 QC 21 - SA	10 pcs	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	APR 23 2020 DAS 70
			QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D3294 C/U File D3294-3 Dwg Rev: 0 Prog Rev: 0 *grain direction on a 45 deg as
 Descriptions: per dwg** 2-Debur if necessary

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - 1-Debur if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

180 - QC5- Inspect part completeness to step on W/O

190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) Start Time: 9:30 M156440 Oven Temperature: 320° Finish 10:00
 Time: _____

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

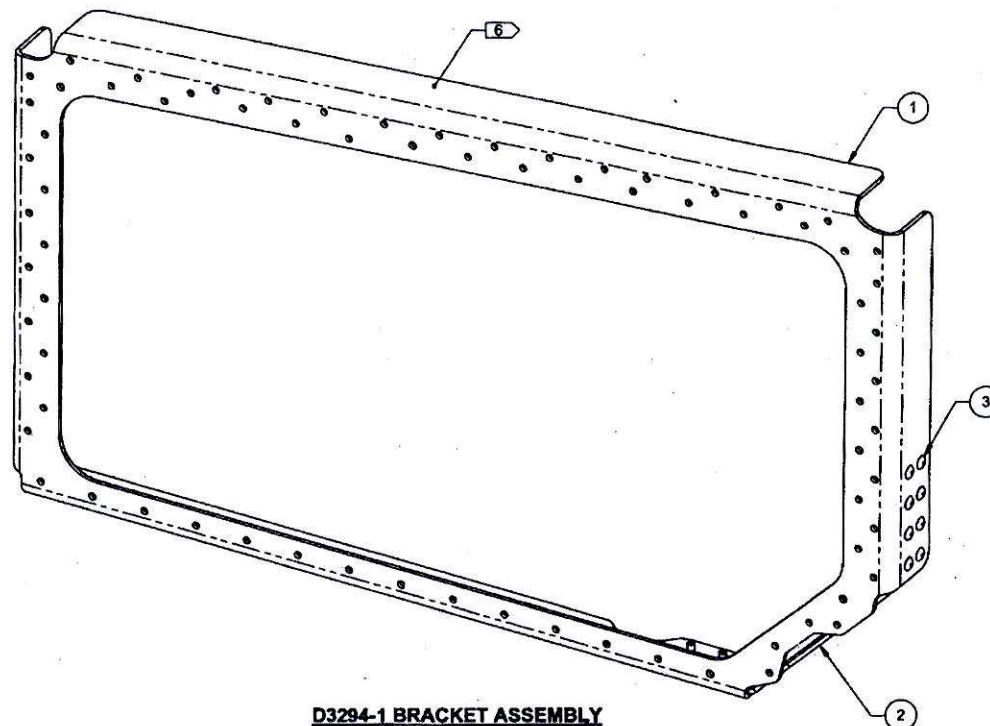
Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	18 sf (1.8 ea)	100-Waterjet - Flow - 1	S176457
D3294-5	Doubler	10 pcs (1 ea)	170-Small Fab - 2 - B4B	S263390
MS20470AD4-5	Rivet, Universal Head	150 Ea (15 ea)	170-Small Fab - 2 - B4B	S198109

ST311

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	18	67	0
170-Small Fab - 2 - B4B	D3294-5	10	0	0
	MS20470AD4-5	150	1,774	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY -1	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 208149

RELEASED
2012-11-21

D	ADD D3294-1B/3B/3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.08.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3294
REV. D
SHEET 1 OF 9
TITLE BRACKET
SCALE NTS

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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

DART AEROSPACE LTD		Work Order: 208149
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131	/		Tape	
Ø0.141	+0.005/-0.001	0.145	/		Caliper	
6.708	+/-0.010	6.709	/			
1.118	+/-0.010	1.120	/			
5.590	+/-0.010	5.591	/			
1.118	+/-0.010	1.120	/			
13.563	+/-0.010	13.563	/			
1.043	+/-0.010	1.043	/			
0.625	+/-0.010	0.629	/			
0.325	+/-0.010	0.329	/			
0.300	+/-0.010	0.305	/			
0.400	+/-0.010	0.406	/			
6.000	+/-0.010	5.995	/			
1.000	+/-0.010	0.998	/			
17.124	+/-0.010	17.124	/			
16.13	+/-0.030	16.13	/			
7.27	+/-0.030	7.27	/			
11.97	+/-0.030	11.97	/			
8.37	+/-0.030	8.37	/			
20.05	+/-0.030	20.05	/			
12.98	+/-0.030	12.98	/			
14.59	+/-0.030	14.59	/			
11.66	+/-0.030	11.66	/			
0.080	+/-0.010	0.082	/			

Measured by: TF	Audited by: DAS	Preliminary Approval:
Date: March 20, 2020	Date: 2-5-2020	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	



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CANADA
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Container No: S265436



Part: D3294-1

Job No: 208149

Serial No/Batch: S265436

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/20/20